Work Ordei October-29-13 10		8888		*108	3888*						Page 1
Revision ID:	D2933-1 206 Saddle Let	ì		Accept	*N900	0401	\n\n'	k S	etup Star Stoj	IV	S1* S2*
Start Date: 1 Required Date: 1 Reference:	0/29/13 0/29/13	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item I Customer:	D:		e en e			
		" MLJ	Date: \\\ \\\ \\ \\ \\ \\ \\ \\ \\ \\ \\ \\			ate:	·	R	tun Stai Sto	I/I	R1* R2*
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool ID			Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revi	sion Nbr*								,	, J. F
D2933	Rev	C									
*100 * HAAS I		HAAS CNC VERTIO	CAL MACHINING #1	0.00	onl 13/1	1/05	_	6	· _&_		
HAAS CNC vertical r	machine #1	Program number a inspect a	part number and batch number programmed correctly.2-s per dwg D2933 & attached and visually inspect as per	Machine Step No 1 of Fo	lio and visually						
110				0.00	4	<i>, ,</i> ,					
110 Mill Conv		CONVENTIONAL N Memo	MILLING MACHINE	0.00	onl 13	11106		6			
Conventional Milling	Machine		Keyway and inspect per atta	ched dimension sheet				•			
						- , ,				710	
120		QC1- Inspect dimens	ions to dimension sheet	0.00	and 131	11/06					
120: QC		Memo		0.00	is ·			6	Ø	• •	
Quality Control										:	

DQA:	Date: ed: Date:				. WORK ORDER MON	_	221521					> DART
QA Closed:		Date:			WORK ORDER NON-	-C(ONFOI	RMANCE / UPDATE	W	ork Order up	odate only	AEROSPACE
Work Orde	or.				DISPOSITION			AGAINS	T DE	PARTMENT	/PROCESS	
Part N					Rework Scrap			Skid-tube Crosstub Machining Small Fal	-	Pro	Water Jet	Engineering Quality
NCR N	No				Use-as-is Suspected Unapproved		Thern	noforming Finishin Large Fab Composite	_	-1	re/Packaging Supplier	Other
Root				Desc	ription of work order update		Initial	Action		Sign &		
Cause	Date	Step	Qty		or non-conformance	1	nief Eng			Date	Verification	QC Inspector
Design						l		'				
Doc/Data												
Equip/Tooling					*							
Handling/Pre						l						
Material												
Operator			•									
Offset/Setup				-								
Process					•							
Supplier												
Training												
Transport						l						
Unapproved												İ
			1			FAI	ULT CAT	regory				
Landir	ng Gear			-	General					· · · · · · · · · · · · · · · · · · ·		
	Bending				Bend		Folio/P	rogram	Г	Outside Dim	ensions T	Pressure/Forced
	Centre N	ot Concer	ntric		BOM/Route		Grain	· ·		Over/Under	-	Set-up
	Cracks				Broken/Damage/Defect		Hardwa	re		Part Incorred	-	Temperature/Cure
	Crimp/Kii	nk/Ripple	/Wave		Burrs		Inspecti	on Incomplete/Unqualified		Part Lost/Mi	⊢	Weld
	Cuffs				Contamination		1	ions Incomplete/Unclear		Part Moved	-	Wrong Stock Pulled
	Crushing				Countersink		4	ned/off center	 	Positioned W	L_ Vrong	
	Heat Trea				Cut Too Short		Mislabe	•	_	Power Loss/:		Other
İ	Inspectio	n Strip in	Tube		Drawing	$\overline{}$	Misread		_	1. 2.1.2. 2003/.		o and
ľ	Marks/Ch	•			Drill Holes	-	Off-set					
	Turning S	Sequence			Finish	\vdash	1	Calibration				
	Wave/Tw		e		Fit/Function		4	Sequence				····

*108888

Page 2

October-29-13 10:13:05 AM

Required Date: 10/29/13

Item ID: **Revision ID:** Item Name:

D2933-1

Accept

N900040100

Setup Start

Start Date:

10/29/13

206 Saddle Left

Start Qty: 4.00 **Rea'd Oty:** 4.00

QC:

Operation

Date: _____

Cust Item ID:

Customer:

Reference:

Approvals:

Sequence ID/

Process Plan:

Date:

Tooling:

Date:

Date:

Stop

130

Work Center ID Description

QC8- Inspect parts - second check

Run Hours - 0.00

Set Up/

SPC (Y/N):

Tool ID

Tool # Plan Accept Qty Code

Reject **Qty**

Run

Reject Insp. Number Stamp

2AC

130

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish Hand Finishing Memo

0.00

16 13-11-9

150

150

Powdercoat Powder Coating White Gloss(Ref.4.3-5.1) per QSI005 4.3-Alum

0.00

Memo

0.00

FINISH TIME:

OVEN PEMPERATURE:

6 \$ 13-11-11

DAS 34

4

DQA:			Date:			WORK OBDED NON	~	ANEO	DRAANICE / LIDDATE				
QA Closed:			Date:			WORK ORDER NON-	-((JINFUI	RIVIANCE / OPDATE	W	ork Order up	odate only	AEROSPACE
Mork Ord	~ r·					DISPOSITION			AGAINS	T DE	PARTMENT	/PROCESS	
Work Orde	er. -					Rework	ıl		Skid-tube Crosstub		1	Water let	7
Part f	No.					Scrap			Skid-tube Crosstub Machining Small Fa		Dro	Water Jet d. Eng. Coor.	Engineering Quality
rarei	•••					Use-as-is		1	noforming Finishir	-	-1	re/Packaging	Other
NCR f	No.					Suspected Unapproved		Incin	Large Fab Composit	~	1 1100/3101	Supplier	
	-						1				_	- app	
Root					Desc	ription of work order update	Ī	nitial	Action		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design		-											
Doc/Data	Ш												
Equip/Tooling	Ш												
Handling/Pre	Ш												
Material	Ш												
Operator	Ш				,								
Offset/Setup	Ш												
Process													
Supplier													
Training													
Transport													
Unapproved													
							FAI	ULT CAT	EGORY				
Landi	ng G	ear				General					_		
		Bending			L	Bend		Folio/F	rogram		Outside Dim	ensions	Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
		Cracks				Broken/Damage/Defect		Hardwa	re		Part Incorred	ct	Temperature/Cure
	Щ	Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	on Incomplete/Unqualified		Part Lost/Mi	ssing	Weld
	$\bigsqcup_{}^{}$	Cuffs				Contamination		Instruct	ions Incomplete/Unclear		Part Moved		Wrong Stock Pulled
		Crushing				Countersink		Misalig	ned/off center		Positioned W	Vrong	-
1	Ш	Heat Trea	t			Cut Too Short		Mislabe	led		Power Loss/:	Surge	Other
		Inspection	n Strip in	Tube		Drawing		Misread	i				
	Ш	Marks/Ch	atter			Drill Holes		Off-set					
		Turning S	equence			Finish		Out of 0	Calibration				
		Wave/Tw	ist in Tub	e		Fit/Function		Out of 9	Sequence				

Work	Order	ID	10	8
			== :	

Work Orde				*10	ጸጸጸ	38*				<u> </u>		Page 3
Revision ID:	D2933-1 206 Saddle L	eft	A	Accept	*	1900	040	100)* s	etup Sta	IVI	S1* S2*
Start Date: Required Date: Reference:	10/29/13 10/29/13	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*			Cust Item I Customer:	D:					
Approvals:		an:	Date:	Tooling: SPC (Y/N):			ate:		R	kun Sta Sto	D	R1* R2*
Sequence ID/ Work Center II 160 *1 A A * QC Quality Control)	Operation Description QC3- Inspect Part Finish Memo		Set Up/ Run Houps 0.00 27 9-8 0.00	7	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 Packaging Packaging		Identify as per dwg & Stor	ck Location: <u>ST43</u> 7	0.00					6x	DAS 28 989	13-11	<u>//</u>
*180 *180* QC Quality Control		QC21- Final Inspection - Memo	Work Order Release ·	0.00					ML	<u> </u>	3-11-1	3 F 13-11-19

DQA:								_					•	AA PT
QA Closed:		Date:			WORK ORDER NON-	-C(ONFO	RMANCE / UP		Wo	ork Order up	odate only	\neg	AEROSPACE
Work Orde	ar.	•			DISPOSITION					-	PARTMENT,		1	
Part N					Rework Scrap			Skid-tube Machining	Crosstube Small Fab	_	Pro	Water Jet d. Eng. Coor.		Engineering Quality
NCR N	lo			_	Use-as-is Suspected Unapproved		Thern	noforming Large Fab	Finishing Composite		Rec/Sto	re/Packaging Supplier		Other
Root				Descr	ription of work order update	П	nitial	Acti	on		Sign &			
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption		Date	Verification	,	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved														
Oliappioved						FΔI	ΙΙΤ (Δ)	TEGORY			<u> </u>			
Landir	ng Gear				General		or ca	- LOOK!						
	Cracks Crimp/H Cuffs Crushin Heat Tri Inspecti	Not Concer (ink/Ripple g eat on Strip in Chatter	e/Wave Tube		Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes	-	Grain Hardwa Inspecti Instruct Misalig Mislabe Misread Off-set	ion Incomplete/Uni ions Incomplete/U ined/off center eled			Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance ct ssing Vrong		Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
}		Sequence wist in Tub			Finish Fit/Function		ł	Calibration						
	ivvave/i	WISLIII LUL	JE		IEIVEUNCHON		いいけんたく	eallence						

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

October-29-13 10:13:04 AM

Work Order ID:

108888

Parent Item:

D2933-1

Parent Item Name:

206 Saddle Left

Comments:

IPP: B00.06.26New DWG rev (mpp 2069)EC IPP Rev: C As per Rev C 07-03-19 JLM

Start Date: 10/29/13

Required Date: 10/29/13

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measur	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001 Saddle Billet		Manufactured	No			100	Each	32.0000	1	4			30"
•				Location		Loc Qty	Ī	oc Code					
<i>3</i>				MAT042		32							. *** 1
				1082	272	30				<u>,</u> †	-K 1	7/11/0	es.
				9723	19	2					•	,,,,	7

DQA:		_ Date:										A DT
					WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE				_ AEROSPACE
QA Closed:		Date:							Wo	ork Order up	date only	
Work Orde	er:				DISPOSITION			AGA	AINST DE	PARTMENT	PROCESS	
					Rework			Skid-tube Cross	stube		Water Jet	Engineering
Part N	No.				Scrap			\vdash	ıll Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is		•	~ ` }	ishing	1	re/Packaging	Other
NCR N	No				Suspected Unapproved			·	oosite	·	Supplier	
	·-·		· · · · · · · · · · · · · · · · · · ·							-		
Root			, ,	Desci	ription of work order update	Ī	Initial	Action		Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	rief Eng	Description		Date	Verification	QC Inspector
Design												
Doc/Data					<i>e</i>							
Equip/Tooling												
Handling/Pre		:							:			
Material								·				
Operator												
Offset/Setup												
Process												
Supplier		ĺ										
Training Transport												
Unapproved		<u> </u>					IIIT CAT	 EGORY			<u> </u>	
Landii	ng Gear				General	FA	OLI CA	IEGURY				
	Bending				Bend] Folio/B	rogram		Outside Dime	onsions [Pressure/Forced
		ot Concer	ntric		BOM/Route	\vdash	Grain	Ogram	-	Over/Under	⊢	Set-up
	Cracks				Broken/Damage/Defect	-	Hardwa	re	-	Part Incorrec	 	Temperature/Cure
		nk/Ripple	/Wave		Burrs		1	on Incomplete/Unqualified	d	Part Lost/Mis		Weld
	Cuffs		•	 	Contamination		1 `	ions Incomplete/Unclear	_	Part Moved		Wrong Stock Pulled
	Crushing				Countersink	\vdash	1	ned/off center		Positioned W		J. T. Olig Stock Fulled
	Heat Tre				Cut Too Short		Mislabe		<u> </u>	Power Loss/S		Other
	Inspection	n Strip in	Tube		Drawing	\vdash	Misread		L	1		
	Marks/C	hatter			Drill Holes	-	Off-set					
	Turning S	Sequence			Finish		Out of 0	Calibration				
	Wave/Tv	vist in Tub	ne		Fit/Function		Out of s	Seguence				

DART AEROSPACE LTD	Work Order:	108888
Description: 206 Saddle, Inboard, Left side	Part Number:	D2933-1
Inspection Dwg: D2933 Rev: C DSK: Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

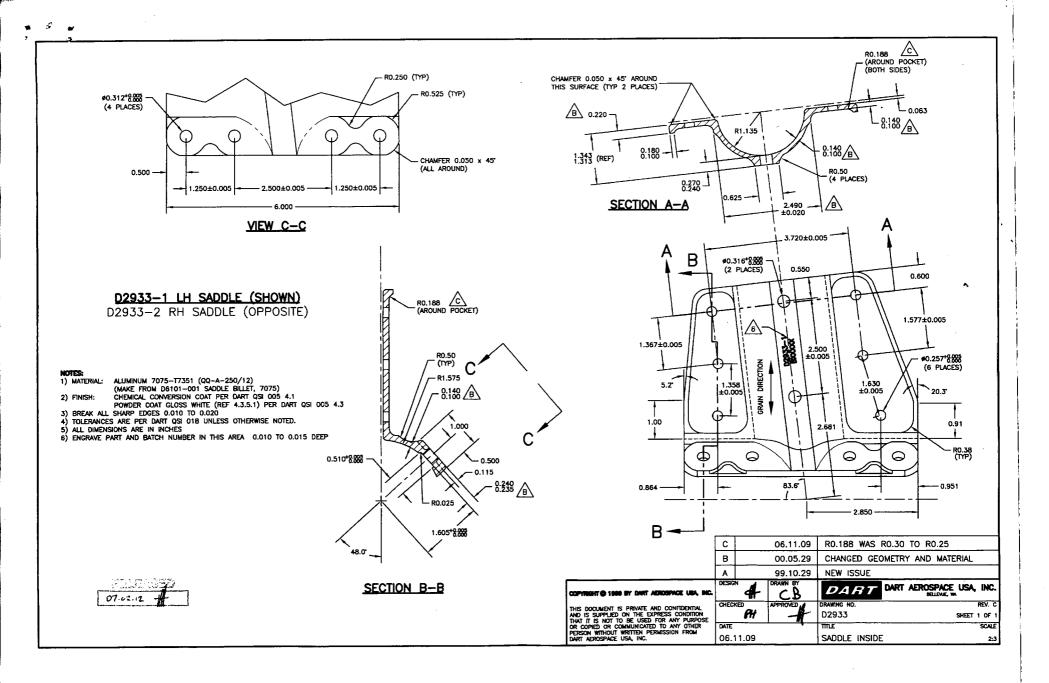
E 1.245 1.255				X First Article Prototype										
Dim Min Max Gauge 1								Record	Actual D)im	ensions			
B	Dim	Min	Ma	х (1		2	3		-	5		
C	Α	0.100	0.14	40		.130	./5	3 <i>0</i>	,13/		.131	130		
D	В	0.100	0.14	40		.130	. /:		.731		.131	.137		
E 1.245 1.255 1.255 1.257 1.250 1.25	С	0.100	0.14	40		.113	. 1	18	.120		.119	120		
F	D	0.210	0.2	30		.224	.,2	23	.22	/	.224	· • • - / _		
G 2.495 2.505 2.506 2.506 2.506 2.506 2.506 2.506 2.507	E	1.245	1.2	55		1.250	1.	250	1.250	2	1,250			
H	F	1.245	1.2	55		1.250	1.	257	1.257)	1,250	1,250		
1.572	G	2.495	2.5	05		2.500	2	500	2.50)	2.500	<u> えあり</u>		
J 2.498 2.505 2.507 2.507 2.500	Н	0.510				.57.2	. &	572	. 572		- 3/2	·\$22		
K						1.578	1.	577		7		1.577		
L	J	2.495				2.500				2	2.500	2.500		
L	K					259			.259	7	259			
N	L					.314	1.3	314	1.314		-314	.314		
N	М					.234	1.2	<u> </u>	.236		.236	1236		
P	N	0.100				125	L. 1.	24	124		.124			
Q 3.715 3.725 3.72b						576	. 2	546			.546			
R 2.470 2.510 2.49D 2.49	Р					.500	. 4	500						
S						-		7 00		D				
T		2.470				2,490		111/	2,77	2		~ / / ~		
U 1.625 1.635 7.630	S	0.240				.254	. 2	54		1	.2 5 3	<u> </u>		
V 1.362 1.372 1.367	Т	0.100	0.1	80		./35	./		1 , ,		./35			
W 0.316 0.321 .3/7 .	U					1.630	1.	630	1.631	2	1.636	1.1.30		
X						1.367	1/.	367	1.36	Z.	1.367	1.367		
Y 1.565 1.585						1.3/7	1, -	3/7	1.3/7	2		\ <u></u> /		
Z 0.178 0.198 .788 .						1,/35	1/./	35	1./3	_ ح		117		
AA						1.572	1.5	572	1.57	3	1.5725	1.5725		
AB		0.178	0.1	98		· /88	1./	<u>88 </u>	1.188		.188	./88		
AC							<u> </u>							
AD							<u> </u>		ļ					
Accept/Reject Date: 3/11/05							-							
Measured by: Date: 13 11 05							 		 			-		
Date: 3 05	_AE						 		<u> </u>					
N/A Date: 3 11 00					cept/Reject		<u> </u>							
N/A Date: 3 11 00		Measure	d by:			- Min								
Prototype Approval: N/A Rev Date Change Revised by Approv A New Issue RF B 02.12.12 Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B KJ/RF C 06.10.03 Removed DT8683, DT8686 & DT8690 KJ/JLM D 07.03.21 Revised per drawing revision C KJ/JLM		Audite	d by:	م. در		08			Da	ite:	13/11	108		
A New Issue RF B 02.12.12 Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B KJ/RF C 06.10.03 Removed DT8683, DT8686 & DT8690 KJ/JLM D 07.03.21 Revised per drawing revision C KJ/JLM	Proto	otype Appr	oval:		W. 1889. W	N/A 9-89			Da	ite:	<u> </u>	V/A		
A New Issue RF B 02.12.12 Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & Large DT8695 A/B KJ/RF C 06.10.03 Removed DT8683, DT8686 & DT8690 KJ/JLM D 07.03.21 Revised per drawing revision C KJ/JLM	Rev	Date	Chang	e								Approved		
B 02.12.12 Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & KJ/RF C 06.10.03 Removed DT8683, DT8686 & DT8690 KJ/JLM D 07.03.21 Revised per drawing revision C KJ/JLM			New Is	sue						RI	F			
C 06.10.03 Removed DT8683, DT8686 & DT8690 KJ/JLM D 07.03.21 Revised per drawing revision C KJ/JLM		02.12.12			ed Dim. X-Y	, DT8683, D1	868	6, DT86	90 &	K	J/RF			
D 07.03.21 Revised per drawing revision C KJ/JLM	С	06.10.03			83, DT8686	& DT8690		****	-	K	J/JLM .			
										K	J/JLM , ,			
E 08.01.16 DT8695 A/B removed from dimension Y KJ/EC/DD								73				1		

DART AEROSPACE LTD	Work Order:	108888
Description: 206 Saddle, Inboard, Left side	Part Number:	D2933-1
Inspection Dwg: D2933 Rev: C DSK: Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

			X First A	Article	Prototy	ype			
					Record /	Actual [imen	sions	
Dim	Min	Max	Go/No Go Gauge	16	2	3		4	5
Α	0.100	0.140		./3/					
В	0.100	0.140		./3/					
С	0.100	0.140		119					
D	0.210	0.230		-224					
E	1.245	1.255		1.250					
F	1.245	1.255		1.250					
G	2.495	2.505		2,500					
Н	0.510	0.515		.572					
1	1.572	1.582		1.577					
j	2.495	2.505		2.500					
K	0.257	0.262		.259			_		
L	0.312	0.317		.3/4					
M	0.235	0.240		,237					
N	0.100	0.140		124					
0	0.540	0.560		.545					
Р	0.490	0.510		·50/					
Q	3.715	3.725		3.720			_	<u>.</u>	
R	2.470	2.510		2.490					
S	0.240	0.270		253					
T	0.100	0.180		1,735					
U	1.625	1.635		1.630					
V	1.362	1.372		1.367					
W	0.316	0.321		3/7					
X	1.125	1.145		1.135					
Z	1.565 0.178	1.585 0.198		1.573					
AA	0.176	0.196	,	1. 100					
AB							-		·· ·
AC				 		·			
AD				+			-+		
AE							-+		
			Accept/Reject						
	Measure	d by: 🕒	N/	(A) 8		Da	te:	3/1/	56
	Audite	d by:		08		Da	te:	13 11	08
Prote	otype Appr			N/A		Da	ite:		/A
Rev	Date	Change	-					sed by	Approved
Α		New Issue					RF		
В	02.12.12	DT8695 A/B	dded Dim. X-Y		686, DT869	0 &	KJ/R		
С	06.10.03		8683, DT8686				KJ/J		
D	07.03.21		drawing revisio				KJ/J	LM ,A	<u></u>
E	08.01.16	DT8695 A/B	removed from	dimension Y			KJ/E	C/DD	137

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108888 MLJ 13-10-29